

Date: Friday, 11/07/2008 10:02:35 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B LOW GEAR WEB		
Job Number	: 40432		Part Number	: D26541		
Estimate Number	: 11768		Drawing Number	: D2654 REVE1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 11/07/2008 S.O. No. :		Drawing Revision	: E1		
Prsht Rev.	: NC		Material	:		
First Issue	: 11 Type : SKIDTUBES		Due Date	: 18/07/2008 Qty: 3 Um: Each		
Previous Run	: 40405					
Written By	:					
Checked & Approved By	: JUL 08.7.11					
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:E 08-06-10 revE1 as per dwg DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)	
		Pick:	
	Qty	Part Number	Description
	1	D2600-5	Web
			Batch <u>B29985</u> ③ M 3-7-14
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Cut D2600-5 to length as per Dwg D2654 (73.85")	
		2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654	
		3-Using the uni-bit, open holes to finish size as per Dwg D2654	
		4-Deburr holes and ends	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>8/08/08/14 (X3)</u>
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Acid etch and Alodine as per QSI 005 4.1	
			③ M 3-7-14

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 A/B LOW GEAR WEB

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AT 08-07-14 X3

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: L.O.

③

1 8-7-14

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-07-14

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

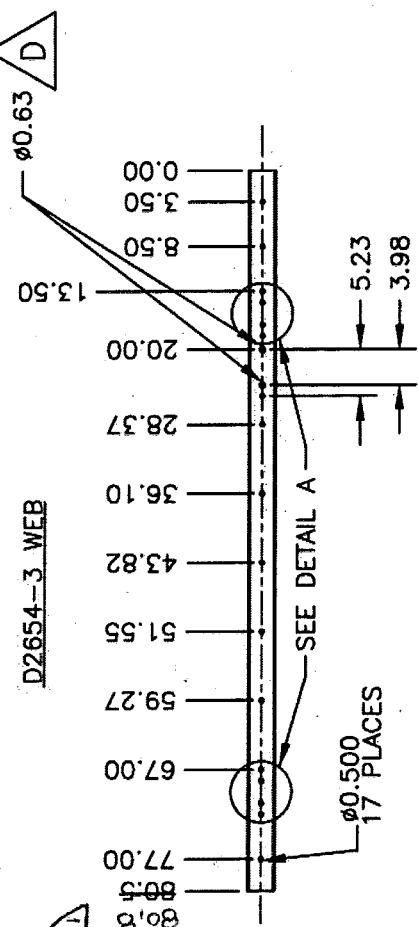
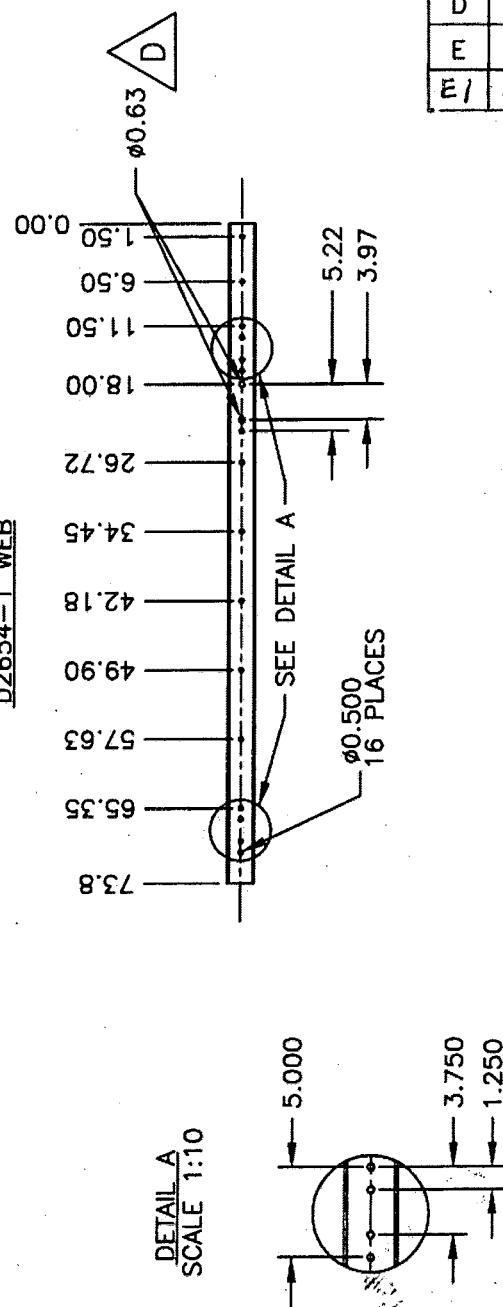
NOTE: Date & initial all entries

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB
04.05.26		SCALE 1:20

**RELEASED**  
04.06.22

D2654-1 WEB



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WORK ORDER  
NO. 40432

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

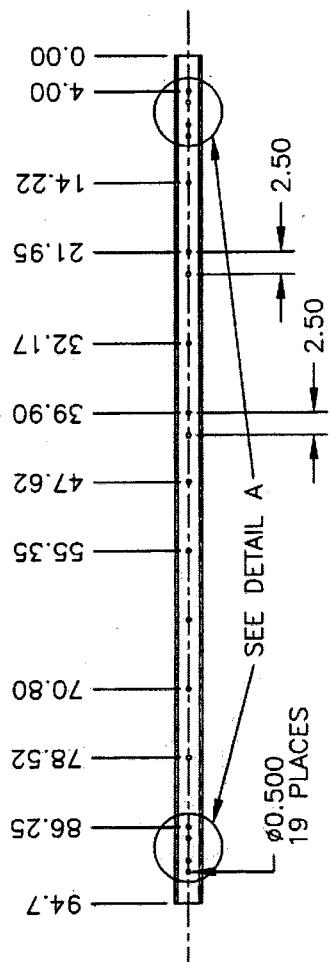
NOTE: Date & initial all entries



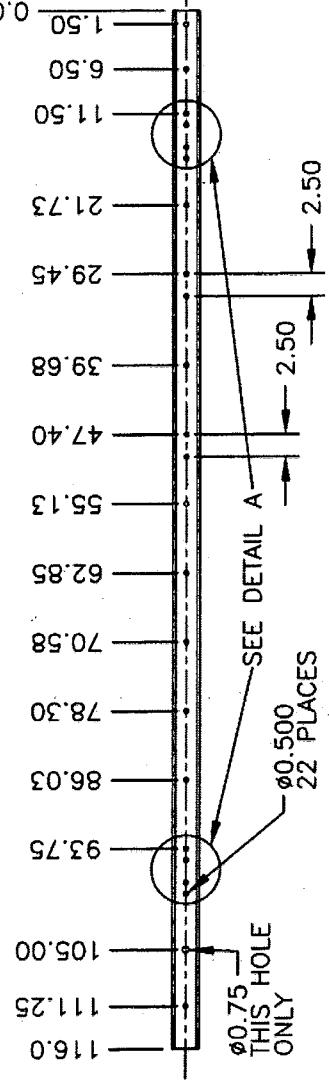
DESIGN <i>CP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <del>      </del>	APPROVED <del>      </del>	DRAWING NO. D2654	REV. E SHEET 2 OF 2	
DATE 04.05.26		TITLE WEB	SCALE 1:20	

RELEASED  
04.08.2014

D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ONE  
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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries